

Classifications

DIN 8555

MF 8-GF-150-KP

Characteristics

Flux-cored wire for gas shielded arc welding giving a 18% Cr - 8% Ni - 7% Mn deposit. Good weldability with either CO₂ or mixed gas. Weld metal has excellent crack resistance even in restrained conditions.

Microstructure: Austenite + 2% Ferrite

Machinability: Good with metallic carbides tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: As required

Shielding gas: Argon 82% + CO₂ 18% (M21) or 100% CO₂

Field of use

Joining of wear plates on shovel buckets, railways and tramway lines, press rams, joining of stainless steels with carbon manganese steels, building up and buttering before hardfacing, welding of 14%Mn steels, armour and hard to weld steels.

Typical analysis in %

C	Mn	Si	Cr	Ni	Fe	Cu
0,1	7,1	0,8	17,9	8,5	balance	0,2

Typical mechanical properties

Hardness as welded: 155 HB

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	100-250	18-30	20 max.	12-15
1,6	180-300	23-30	20 max.	15-18